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(84) Apparatus for and method of testing the conductive properties of a conductor.

(57) The Figure shows a system for non-destructive detection of current restricting defects, such as cracks, narrowing, intermittent opens etc, in a conductor, e.g. a printed conductor. A composite test signal is applied to the test conductor 3 via probes 1 and 2. The signal is produced by a generator circuit 4 comprising a frequency (f_0) oscillator 5, amplifier 6 and D.C. source 7. The defects in the conductor 3 cause its resistance to vary at the same frequency as the oscillator signal and cause current variations through the conductor. The signal at node 4A comprises a component Vf_0 at frequency f_0 , a component $2f_0GV$ at twice the frequency f_0 due to the resistive variation of the restricting defect and a component $2f_0CV$ at two the frequency f_0 due to the resistance heating of the whole conductor. The f_0 component is rejected by filter 8 and the $2f_0$ components amplified (9) and filtered by band pass filter 10. The amplified filtered signal is supplied as one input to a phase detector 12, the other input being derived from node 4B, frequency doubler 14, band pass filter 15 and phase shifter 16. The detector 12 operates as a phase, sensitive demodulator to suppress the $2f_0CV$ component and to compare the phase of the $2f_0GV$ component with the $2f_0$ component from phase shifter 16. The result of the comparison is manifested as a DC voltage which is logarithmically amplified and applied to indicator meter 18 and, via threshold detector 19, to defect indicator 20.

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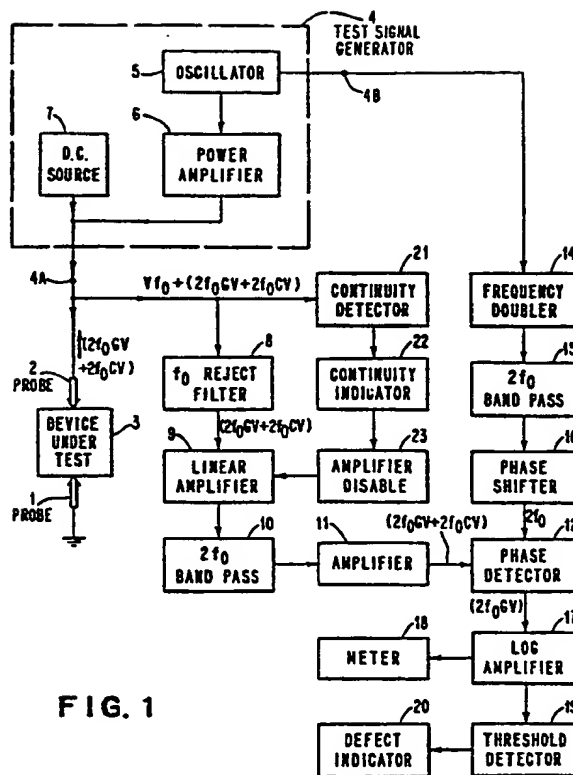


FIG. 1

APPARATUS FOR AND METHOD OF TESTING THE
CONDUCTIVE PROPERTIES OF A CONDUCTOR

This invention relates to apparatus for and method of testing the conductive properties of a conductor.

U S specification No. 3,299,351 (Williams) is concerned with the problem of locating a fault in a cable having a metallic sheath covered by a layer of insulating material and buried in a conducting medium (i.e. the ground). Williams applied a composite signal between the metallic sheath and the conducting medium to establish a voltage field in the medium. The composite signal had an average DC current level of zero and comprised a first component having a fundamental frequency and a second component having an even (e.g. second harmonic frequency). Williams then detects the voltage gradient in the voltage field along the cable using two spaced probes and establishes the position of the fault when the voltage gradient reverses.

U S specification No. 3,500,188 (Whitley) is concerned with the problem of measuring the electrical resistance introduced into a circuit by the interface resistance between two contacting conductors. Whitley, applying the theoretical analysis made by Ragnar Holm in a publication "Electrical Contact Handbook", Springer-Verlag, Berlin 1958, generates an input A.C. signal which is non-symmetrical about its zero axis and has a waveform amplitude providing an average D.C. current level of zero and applies this signal across the interface. He then measures the D.C. potential developed across the interface which he says is a measure of the interface resistance.

A significant and increasingly difficult problem with packaging and interconnection systems in complex circuits such as circuits in computers with high levels of integration is the detection of incipient opens that escape standard conductivity testing of conductors.

The Applicants are concerned with the problem of detecting current constricting defects (such as cracks, narrow conductors, line breaks, intermittent open, etc) in conducting elements, such as printed circuit lines. Neither the Whitley or the Williams proposals are applicable to this problem nor can the Whitley or Williams apparatus be used to solve the Applicants problem.

It is therefore a prime object of the Applicants invention to provide apparatus and a method for detecting current constricting defects in conductors. In accordance with this object such defects are detected by detecting the second harmonic voltage signal produced by passing a composite AC plus DC test signal through the conductor. The test signal generator is balanced and adjusted to provide a signal which is symmetrical and thus provides little even harmonic distortion. The second harmonic voltages across the conductor result primarily from conductor nonlinearities (incipient faults) and the use of the second harmonic technique provides testing capability for such nonlinearities which are not detectable by ordinary testing techniques. The theory of operation depends upon local changes of resistance caused by ohmic heating in nonlinearities which, while conductive, might be expected to fail early during the normal life of the conductor. The composite alternating current plus direct current test signal passes through the conductive path being tested in an unbalanced wave and, upon encountering a local constriction, causes a small volume of metal in the constriction rapidly to heat and cool in a fashion to generate second harmonic signals in close phase relationship to the unbalanced wave. This temperature change produces a resistance change which varies monotonically with the temperature in response to the AC plus DC current at the frequency of the resistance change. The resistance change produces time varying voltage components at frequencies including the fundamental frequency, second harmonic, third harmonic, fourth harmonic and additional harmonics.

The second harmonic signal is the largest signal easily distinguished from the fundamental; it is the second harmonic signal that is amplified and detected.

This nonlinearity-generated signal may be several orders of magnitude smaller than very similar signals reflected from a good conductor of relatively great length occurring as a result of resistance heating. There is, however, a phase difference which permits the good conductor generated signals to be filtered out, thus isolating the constriction defect generated signal.

A feature of the invention is the use of the second harmonic nonlinearity-generated signal ($2f_0GV$) together with phase detection to eliminate the effects of good conductor signal reflections ($2f_0CV$).

Some of the advantages of using second harmonic signals are:

- 1) Symmetrically balanced signal sources have more inherent third harmonic distortion than second. Thus, the ultimate sensitivity of the second harmonic signal is greater.
- 2) Amplifiers that are used to detect the signal will distort more at $3f_0$ than $2f_0$. This gives erroneous signals.
- 3) The DC drive signal can be used in testing for $2f_0GV$ and is proportional to the signal generated. In third harmonic testers, the DC has no effect.

According to the invention there is provided apparatus for testing the conductive properties of a conductor, comprising a test signal generator for providing a periodically varying composite test signal comprising a DC current component and an AC current component and for providing a periodically varying comparison signal having the same frequency as the test signal, said composite signal being such that when applied to a conductor comprising a conductive property capable of periodically

varying in value at the same frequency as the test signal, a fault signal is produced including a fault component periodically varying at twice the frequency of the test signal; circuit means for applying the test signal to the conductor to be tested; frequency doubling means connected to receive the comparison signal for providing a reference signal having twice the frequency of the comparison signal; first means connected to the circuit means so as to receive the fault signal, for separating the fault component therefrom; phase comparing means connected to receive the reference signal and the fault component for comparing the phase of the two received signal and providing an output signal indicative of the result of the comparison; and means responsive to the output signal for providing an indication of any varying conductive property.

According to the invention there is also provided a method of testing for varying resistance of a conductor when subject to a varying current, said method comprising generating and applying a composite test signal to the conductor, said signal comprising DC and AC components and having a fundamental frequency; generating a reference signal having twice the fundamental frequency and a predetermined phase relationship with the test signal; deriving a signal from the current flowing in the conductor and selecting from that signal any fault-indicating component having a frequency twice the fundamental frequency; comparing the phase of the fault component and the reference signal; and providing an indication of a detected fault as a result of the comparison.

The invention will now be further described with reference to the accompanying drawings, in which:-

FIG. 1 is an electrical block diagram showing the invention in operation.

FIG. 2A is a diagrammatic presentation of a resistive constriction in a conductor; FIG. 2B is the related current/voltage chart.

FIG. 3A is a diagrammatic presentation of a tunnelling constriction in a conductor; FIG. 3B is the related current/voltage chart.

FIG. 4 is a diagrammatic presentation of a nonlinearity in a conductor.

FIGS. 5 and 6 are composite current-resistance-voltage charts on a time scale, showing frequency related effects.

FIGS. 7, 8 and 9 are graphs showing the voltage/frequency/phase/resistance relationships of signals produced during testing by the normal resistance heating of the conductor and by the dynamics of the defect,

FIG. 10 is a graph for a copper conductor of the test frequency f_c in hertz against the defect length in mils (0.0254 mm),

FIG. 11 is a graph of the non-linear conductivity of a conductor (NLC) expressed in microvolts per ampere (peak) cubed ($\mu V/A_p^3$), and

FIG. 12 is a graph of construction length against the area of the construction, squared.

DESCRIPTION OF THE PREFERRED EMBODIMENT

FIG. 1 is a block diagram of the tester of the invention. Probes 1 and 2 connect the circuit on the device 3 under test (which may be a printed circuit board) to a composite test signal tap 4A on test signal generator 4, which comprises oscillator 5 and power amplifier 6, and DC source 7. The test signal from tap 4A is applied via probes 1 and 2 to the appropriate circuit of device 3 which is under test. If the device under test is free of nonlinearity faults there will be no significant generated harmonics. If, however, the device under test contains a nonlinearity (such as a crack which is subject to ohmic heating) there will be a nonlinearity generated signal including harmonics. The second harmonic is most significant.

The device under test is connected to f_0 reject filter 8 to reject the test signal fundamental frequency (f_0) and, of course, the test signal

direct current component. The output of filter 8 is amplified by linear amplifier 9, filtered through a second harmonic band pass filter 10 and amplifier 11, and provided to phase detector 12. Phase detector 12 thus has applied to it, from amplifier 11, the amplified second harmonic generated by the nonlinearity fault of the device under test. In order to determine the scope of the nonlinearity fault, phase detector 12 has applied to it a second harmonic signal, from f_0 tap 4B, derived from oscillator 5 of the test signal generator 4. The fundamental frequency is doubled by frequency doubler 14, filtered through band pass filter 15 at $2f_0$, and phase shifted by phase shifter 16. In order to reduce the noise on the relatively small second harmonic signal generated by the nonlinearity fault, and to obtain phase discrimination from signals generated along the length of a good conductor, the fault signal is phase-sensitive-demodulated and converted to a direct current voltage. This direct current voltage is amplified by logarithmic amplifier 17 to get a wide range of readings. The output of amplifier 17 can be connected to a meter 18 or a go, no-go threshold detector 19 with a defect indicator 20 such as an indicator light, marker or sorting device.

In order to make the tester easy to use, a continuity detector 21 and continuity indicator 22 are used. When continuity is not made between the probes and the device under test, the linear signal amplifier is disabled by amplifier disabling circuit 23 so false readings are not made.

THEORY AND OPERATION

The theory of operation depends upon second harmonic signals generated from a local change of resistance caused by ohmic heating at the nonlinearity and the characteristic heating-cooling cycle at the nonlinearity which differs markedly (as to phase) from the characteristic heating-cooling cycle of the conductor along its length. Cooling at the nonlinearity is fast, due to conductive heat transfer to adjacent volumes of cooler metallic conductor, and heating is relatively

fast because of conductor constriction, localized higher currents, eddy currents and localized heat buildup causing even higher resistances. The heat cycle is closely related to the phase of the AC signal.

Cooling along the length of the good conductive element is relatively slow, and heat buildup to a maximum occurs due to the heat insulating properties of the insulation and the fact that incremental volumes of the metallic conductor have no adjacent volumes of cooler metallic conductor. The heat cycle is not closely related to the phase of the AC signal, differing by approximately 90° . When a current source consisting of an alternating current with a direct current flows through a constricted conductor, the small volume of metal rapidly heats and cools asymmetrically on the half wave enhanced by the DC bias. This produces a resistance change which varies monotonically with the temperature change. The current flowing through this changing resistance produces a voltage response which has nonlinear components including even harmonics of the current drive.

When a small defect exists in a long conducting line, it is normally difficult to distinguish between second harmonic signals from the defect and the line. In fact, the second harmonic generated signal from a good conducting line could be much greater in amplitude than the signal from a defect. In order to distinguish between the two signals, some characteristic differences should be recognized. In a defect, the temperature rise and fall due to the drive signal follows the power waveform closely, because of a short thermal time constant, producing resistance changes and second harmonic voltage changes of a particular phase. In a long conducting line, the temperature rises and falls due to the drive signal are integrated, due to long thermal time constants, and the resulting second harmonic generated voltage is phase-shifted with respect to the signal from a defect.

If the phase detector is aligned so that the second harmonic from a long conducting line is nulled out, only defect signals will be detected.

It should be noted that an optimum drive frequency should be used so that the amplitude of the signal from a good conductor is small and yet should have a large phase difference from the signal due to a defect.

Because the heating and cooling in a long conducting line is integrated, higher frequencies cause a smaller signal. At some higher frequency, the signal from the defect will become smaller and will phase shift. Therefore, the optimum frequency of operation is one that is high enough to provide a small signal from the conducting line and low enough so that the defect signal is not reduced or phase-shifted.

The drive current is $I = I_0 + I_1 \sin \omega t$; the resistance change with temperature is $r = r_0 (1 + \alpha \Delta T + \beta (\Delta T)^2 + \gamma (\Delta T)^3 \dots)$. α is a constant. For copper it is 0.00393 per $^{\circ}\text{C}$. ΔT is equal to K times the power dissipated at the constriction. K depends on the physical dimensions of the constriction and other components producing the thermal time constant. Dimensions of K are $^{\circ}\text{C}/\text{watt}$.

The sine wave source is balanced in such a way as to minimize the second harmonic signal when no defect is present in the conductor under test. It is essential to the operation of this second harmonic technique that the source current contain both a DC and a pure sine wave AC component. Without the DC component, a nonlinearly conductive defect would produce a voltage signal containing only odd harmonics.

In implementing this technique for detecting nonlinear conducting elements, the third harmonic component is not detected, as is done in the prior art, because the third harmonic produced by the defect would be mixed with the signal resulting from third harmonic impurity in the source current. The source impurity would then mask the presence of any nonlinear conductivity due to conductor defect. Typically, a sine wave current source will exhibit large odd harmonic impurities (including the third) that are due to cross over distortion, saturation, etc., that cannot be eliminated by carefully balancing the circuitry. By detecting the second harmonic signal produced by a pure DC plus a carefully

balanced AC source, instead of detecting the third harmonic, a sensitivity to nonlinearities several orders of magnitude larger than previous methods is obtained.

The theory of operation is described for a model current constriction as shown in FIGS. 2 and 2B. The approximation is made that the constriction cools by conduction of heat out to the main body of the conductor. The second harmonic voltage produced by a current $i = I_0 + I_1 \cos 2\pi ft$ is:

$$V_{2f} = I_0 I_1^2 \frac{\alpha \rho^2}{24} \left(\frac{d}{a}\right)^3 \left\{ \frac{2}{1+j\frac{\pi f C d^2}{4\sigma}} + \frac{1}{1+j\frac{\pi f C d^2}{2\sigma}} \right\}$$

$$V_{2f} \approx I_0 I_1^2 \left(\frac{3\alpha}{24\sigma\rho}\right) R^3$$

Where α is the temperature coefficient of resistance of the conductor, ρ is the conductor resistivity, σ is the thermal conductivity, c is the heat capacity of the metal, and R is the total resistance of the constriction. The second harmonic signal falls with frequency above the cut-off frequency $f_c = \frac{8c}{\pi d^2}$, as illustrated by the curved labelled "Defect" in FIG. 7.

As shown in FIG. 2A, conductor 24 has a resistive constriction 25. Local heating at constriction 25 produces a positive second harmonic current/ voltage response different from that of a linear ohmic device as shown in Fig. 2B.

A conductor 26 may have a tunnelling constriction 27, as shown in FIG. 3A. This tunnelling constriction produces a negative second harmonic current/voltage response as shown in FIG. 3B. As shown in FIGS. 4-12, the voltage produced across the constriction is composed of a DC component, a fundamental component, the second harmonic component which we are particularly interested in, and higher frequency components.

FIG. 4 shows in stylized fashion a conductor 28 having a constriction 29 which may be a resistive constriction as shown or may be a tunnelling constriction.

FIG. 5 shows current i , resistance R and voltage V on a time scale with all harmonics included in the R and V waveforms.

FIG. 6 shows the waveforms for i , R and V for the case in which the drive current i is a pure sine wave with no DC component. The odd harmonics are removed from the R waveform and the even harmonics removed from the V waveform.

FIG. 7 is a graph of $\log V_{2f}$ over $\log f$, showing a representative reference line at 1.0 KHz. The voltage of the conductor diminishes on a different response curve than does the voltage across the defect. With a particular frequency (1.0 KHz shown) the second harmonic voltage generated by the defect is near a maximum difference from the second harmonic voltage generated by the conductor.

FIG. 8 is a diagram illustrating the phase difference of the second harmonic signals related respectively to the conductor and to the defect. The defect second harmonic signal closely follows the phase of the applied test signal up to a finite saturation frequency (here shown as >1.0 KHz) while the conductor second harmonic signal lags 90° at the same frequency.

FIG. 9 illustrates the phase detection to discriminate defect signals from conductor signals.

Oscillator 5 produces a low distortion sinewave signal which is buffered by amplifier 6 which provides a high current drive. This is applied through the device 3 under test. A direct current is also applied to the device 3 under test. If a constriction causing heating is encountered, a second harmonic is generated. This second harmonic generated voltage ($2f_0 V_G$) appears with the driving signal and is very

small compared to the drive signal. The fundamental signal V_{f0} is rejected by a filter 8 and the remaining signal is amplified, filtered again, and amplified. The remaining signal has a large component ($2f_0CV$) due to resistance heating along the length of the conductor. In order to null the effect of the $2f_0CV$ noise, the signal is phase-sensitive-demodulated by phase detector 12 and converted to a direct current voltage. This DC voltage is filtered as required by filtering means in phase detector 12. Log amplifier 17 converts to the signal so it can be recognized over 4 to 5 decades of $2f_0GV$ strength. In order to operate the phase-sensitive-detector, a synchronous signal from the oscillator is derived from frequency doubler 14, $2f_0$ band pass filter 15 and phase shifter 16. In order to make the tester easy to use, a continuity detector 21 and continuity indicator 22 are used. Threshold detector 19 and defect indicator 20 are also for ease of use. Both these indicators are placed so that an operator can easily find defects. When continuity is not made between the probes to the device under test, the linear signal amplifier is disabled so false readings are not made.

Devices under test showing $2f_0GV$ have been found to fail in accelerated life test significantly sooner than those not showing $2f_0GV$.

FIG. 9, shown on a 2F scale, illustrates calibration of phase detector 12 of Figure 1. For use in testing a sample, the tester is calibrated for maximum detection of a detector phase to be selected from a range centered slightly above zero (0) degrees out of phase with the AC component of the test signal so as to maximize discrimination between the zero (0) degrees phase of the defect second harmonic signals and the near 90 degrees phase of the good conductor signals. See Fig. 8. Calibration may be done by using as a standard a circuit with known defects or as a standard a circuit known to be defect free.

FIG. 10 is a graph illustrating some of the properties of copper. The unit of the abscissa is the mil (0.0254 mm); the unit of the ordinate is frequency in hertz. As can be seen the cutoff frequency tends to

increase as a function of decreasing length of the defect. Calibration may be optimized by the operator by selection of a frequency appropriate to the type of defect suspected. Frequency F_c (HZ) is the test frequency; the line shows the frequency at which there is 3DB rolloff, where the response is down by a factor of two. Defect length is in mils (mil=1/1000 inch = .0254mm). For example, at an expected defect length of 1.0 mils (.0254mm), the operator would calibrate the tester at 50,000 HZ or below.

FIG. 11 is a theoretical graph of nonlinear conductivity of copper as a function of defect resistance. The nonlinear conductivity (NLC) tends to increase as the resistivity of the defect (RD) increases.

FIG. 12 is a theoretical explanation of graphical form. Fig. 12 relates the length and area of a hypothetical defect in copper with the predicted second harmonic generation. Abscissa numbers are in units of (mil) ². The ordinate numbers are in mils and it is to be noted that the numbers on a log scale. The constriction lengths and constriction areas are related to those shown in Fig. 4 as length D and area A. Figure 12 shows that there are ranges of defects which may be tested for; these defects have differing second harmonic voltage levels. Certain metallurgies may tend to have larger defects, or lower conductivity, than other metallurgies and thus the tester may require differing calibration. The lines on the graph are in microvolts per ampere (peak) cubed i.e. $\mu V/A_p^3$. This graph shows that the second harmonic signals from the defect become very small as the defect detection requirement becomes more stringent. Tiny defects produce tiny signals, which continue to be obscured by large signals from the good conductors.

The foregoing apparatus is frequently able to detect incipient or intermittent faults in circuit patterns, which faults are not detectable through ordinary testing techniques.

CLAIMS

1. Apparatus for testing the conductive properties of a conductor, comprising a test signal generator (4) for providing a periodically varying composite test signal comprising a DC current component and an AC current component and for providing a periodically varying comparison signal having the same frequency as the test signal, said composite signal being such that when applied to a conductor (3) comprising a conductive property capable of periodically varying in value at the same frequency as the test signal, a fault signal is produced including a fault component periodically varying at twice the frequency of the test signal; circuit means (2, 1) for applying the test signal to the conductor to be tested; frequency doubling means (14) connected to receive the comparison signal for providing a reference signal having twice the frequency of the comparison signal; first means (8, 9) connected to the circuit means so as to receive the fault signal, for separating the fault component therefrom; phase comparing means (12) connected to receive the reference signal and the fault component for comparing the phase of the two received signal and providing an output signal indicative of the result of the comparison; and means (17) responsive to the output signal for providing an indication of any varying conductive property.
2. Apparatus as claimed in claim 1, further comprising continuity detecting means connected to the circuit means for detecting when no current flows in the conductor due to a discontinuity and disabling means connected to the detecting means and the first means for preventing operation of the first means when the conductor is discontinuous.
3. Test apparatus for determining the existence of nonlinearity faults in a conductor under test, which conductor is connected by probes to the test apparatus, characterized by:

- a) a test signal generator having a composite test signal node and means to provide at the composite test signal node a composite test signal including a direct current signal of known characteristics and an alternating current signal of known characteristics including a fundamental frequency, and having a fundamental frequency node for providing the fundamental frequency;
- b) connecting means, for connecting the composite test signal node to a device under test in such fashion that nonlinearity anomalies in the device under test provide fault signals including second harmonics of the fundamental frequency;
- c) test signal filtering means, connected to said composite test signal node, to pass only the second harmonic signal from the device under test;
- d) frequency doubling means connected to the fundamental frequency node of said test signal generator to produce second harmonic test signals;
- e) phase detection means having inputs including an input connection from said filtering means for accepting second harmonic signals from the device under test and having further input means for accepting the second harmonic test signals from said frequency doubling means, for detecting fault signals separate from conductor signals differing in phase; and
- f) output means for providing an indication of fault in the device under test.

4. Test apparatus according to Claim 3, further characterized by:
- g) a continuity detector connected to said composite test signal node; and
 - h) disabling means connected to said continuity detector and to said test signal filtering means to prevent passage of spurious test signals when continuity is not made.
5. A method of testing for varying resistance of a conductor when subject to a varying current, said method comprising generating and applying a composite test signal to the conductor, said signal comprising DC and AC components and having a fundamental frequency; generating a reference signal having twice the fundamental frequency and a predetermined phase relationship with the test signal; deriving a signal from the current flowing in the conductor and selecting from that signal any fault-indicating component having a frequency twice the fundamental frequency; comparing the phase of the fault component and the reference signal; and providing an indication of a detected fault as a result of the comparison.
6. A method as claimed in Claim 5, in which the fundamental frequency f_0 of the composite test signal is selected to be within a range of optimum frequencies extending from above the frequency at which second harmonic signals caused by heating and cooling along the conductor length diminish because of integration to below the frequency at which second harmonic signals caused by heating and cooling of defects of the expected type begin to diminish below an acceptable value.

7. A method of testing an electrical conductor for nonlinearity faults, characterized by:

- a) probing the device under test with a composite signal including a DC signal and an AC signal at a characteristic frequency f_0V , whereby nonlinearities in the conductor under test generate second harmonic signals $2f_0GV$ at a first phase relationship, and whereby resistance characteristics of the conductor under test itself generate relatively large second harmonic signals $2f_0CV$;
- b) phase-sensitive-demodulating such fault-generated second harmonic signals $2f_0GV$ using a predetermined standard signal $2f_0$ and phase shift to null the conductor signals $2f_0CV$ and identify as faulty a device under test having $2f_0GV$ signals differing from the standard.

8. A method as claimed in claim 7, further comprising disabling the detecting of spurious second harmonic signals $2f_0GV$ during periods except when continuity has been established.

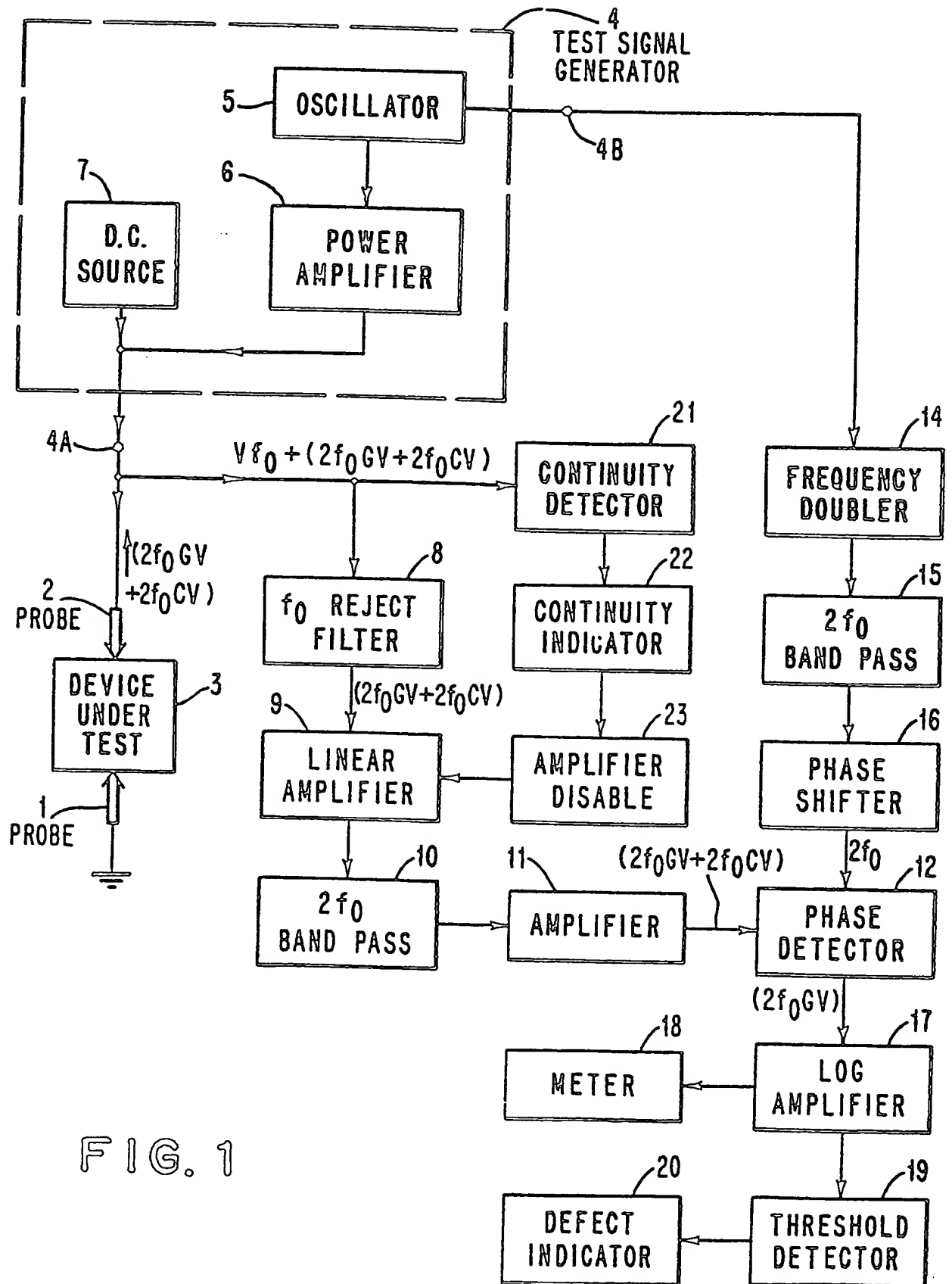


FIG. 1

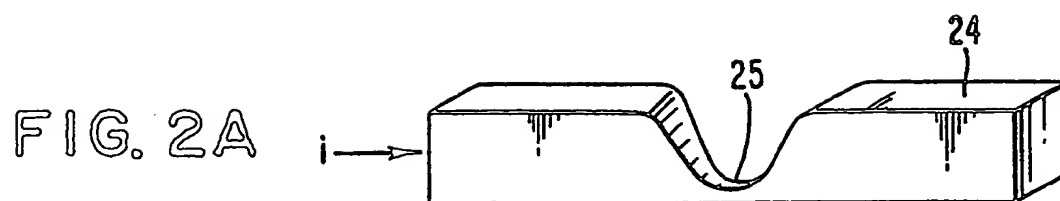


FIG. 2B

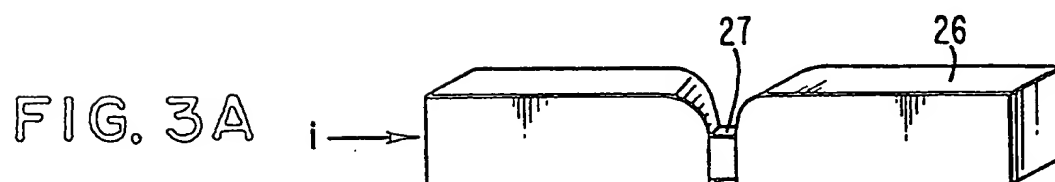
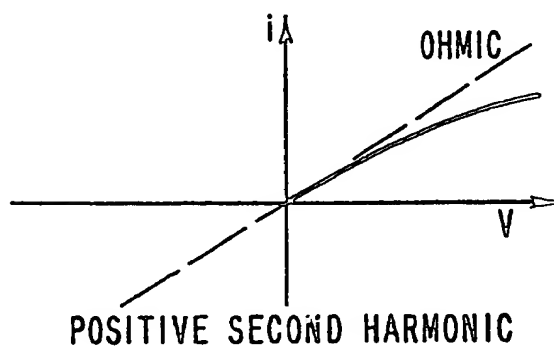


FIG. 3B

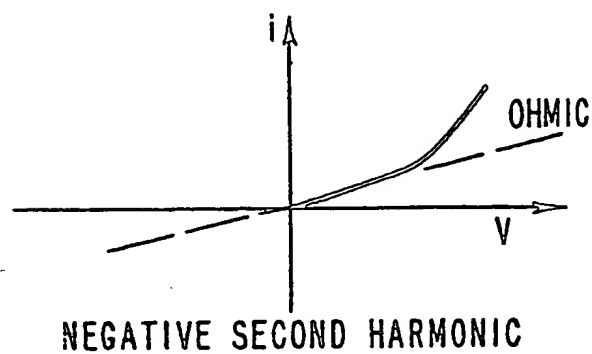


FIG. 4

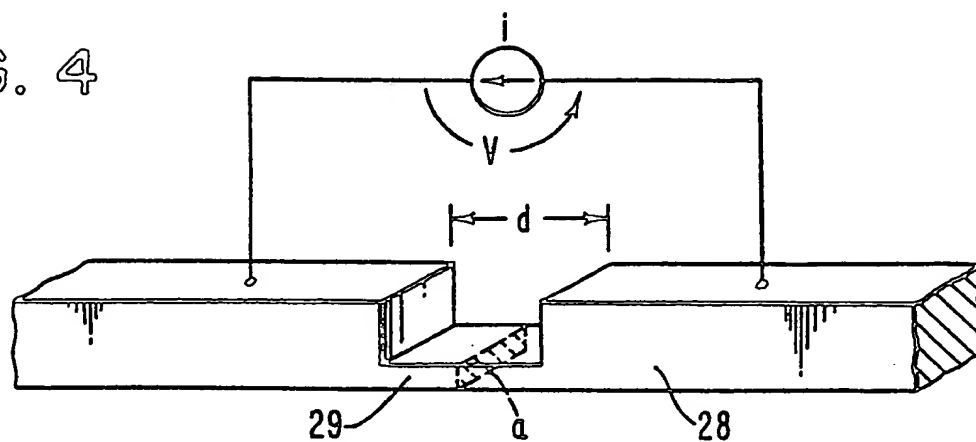


FIG. 5

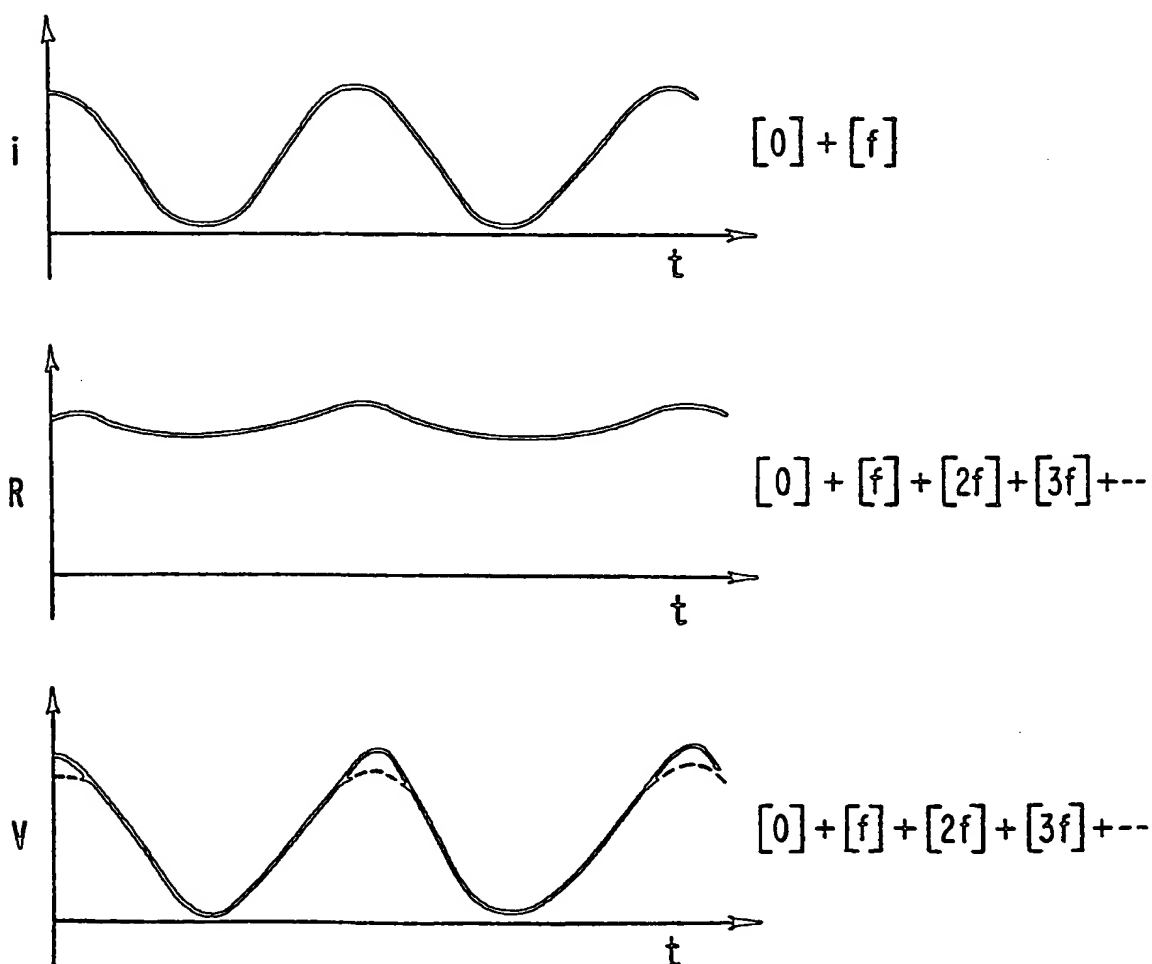


FIG. 6

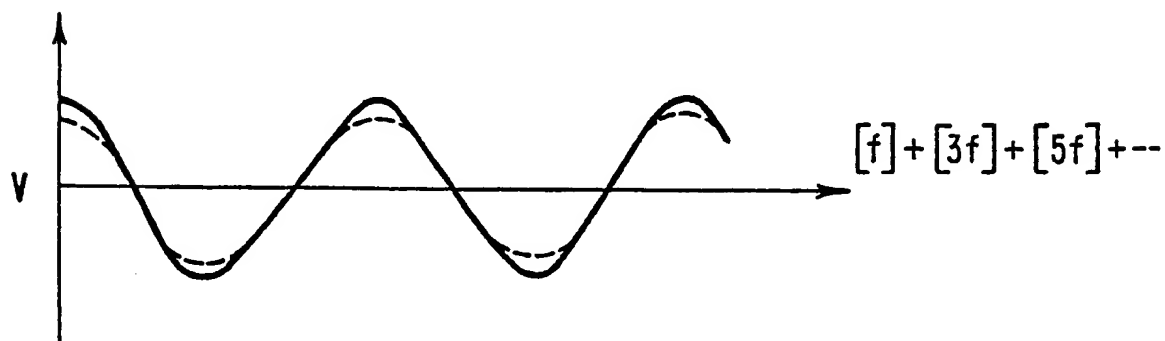
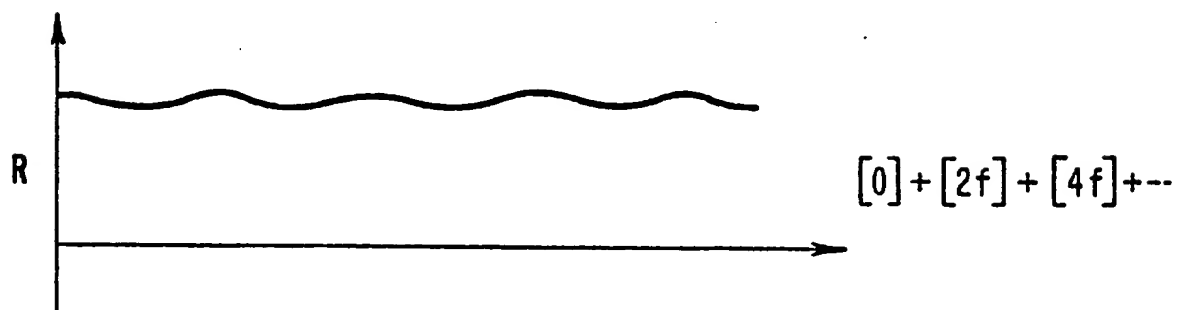
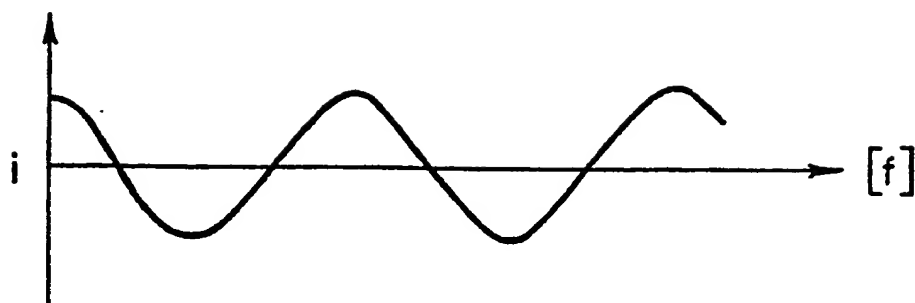


FIG. 7

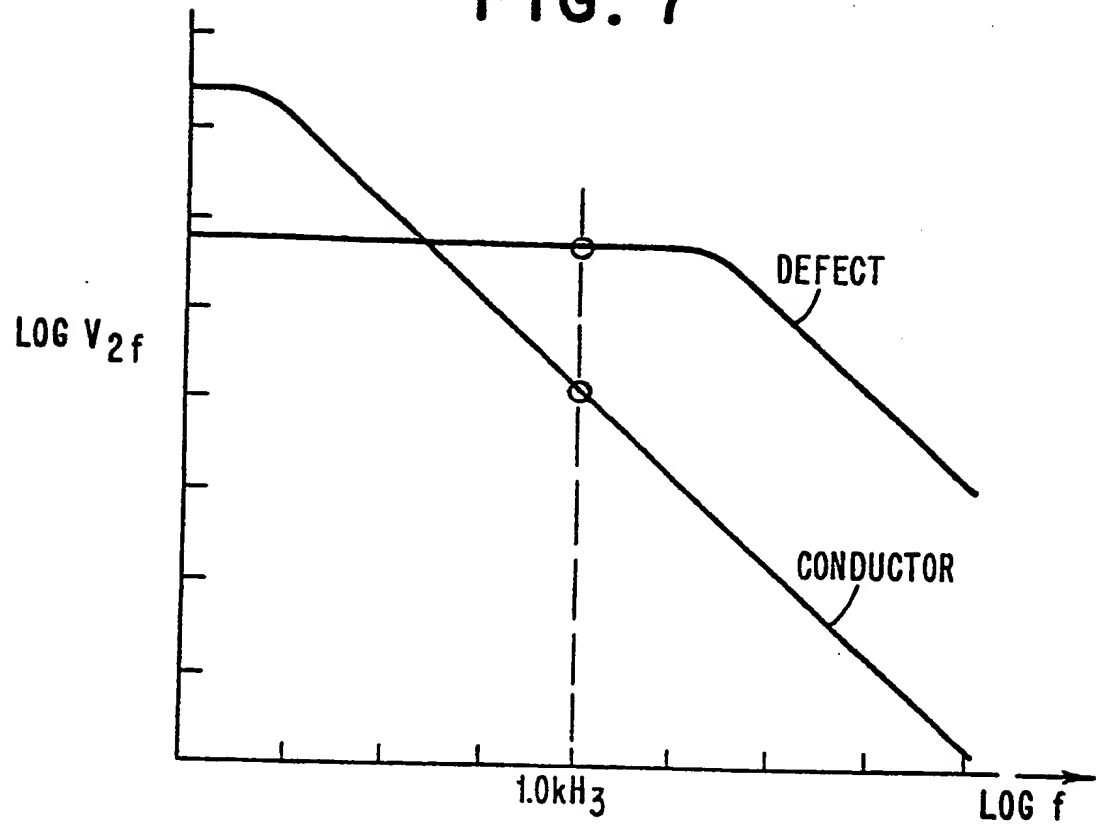


FIG. 8

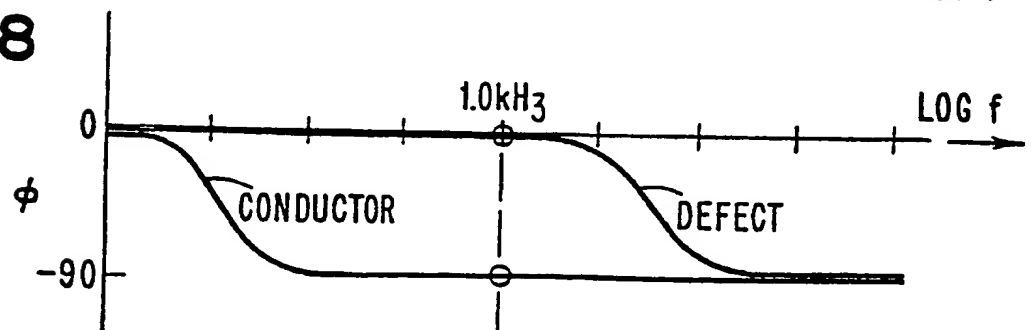


FIG. 9

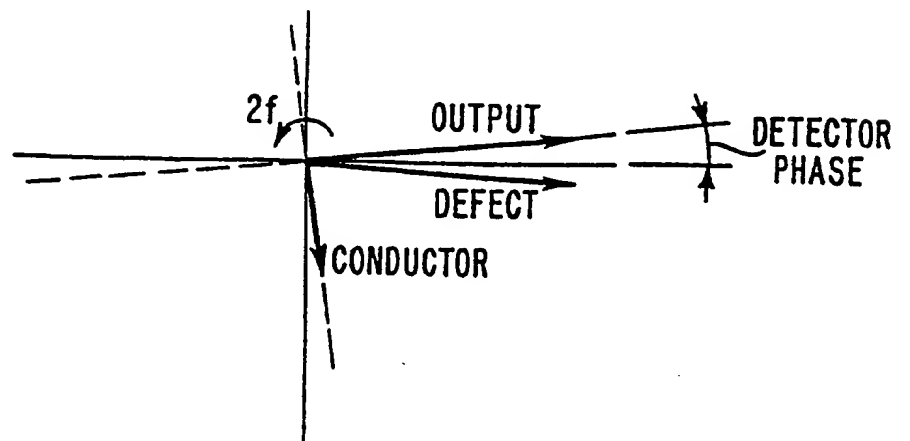


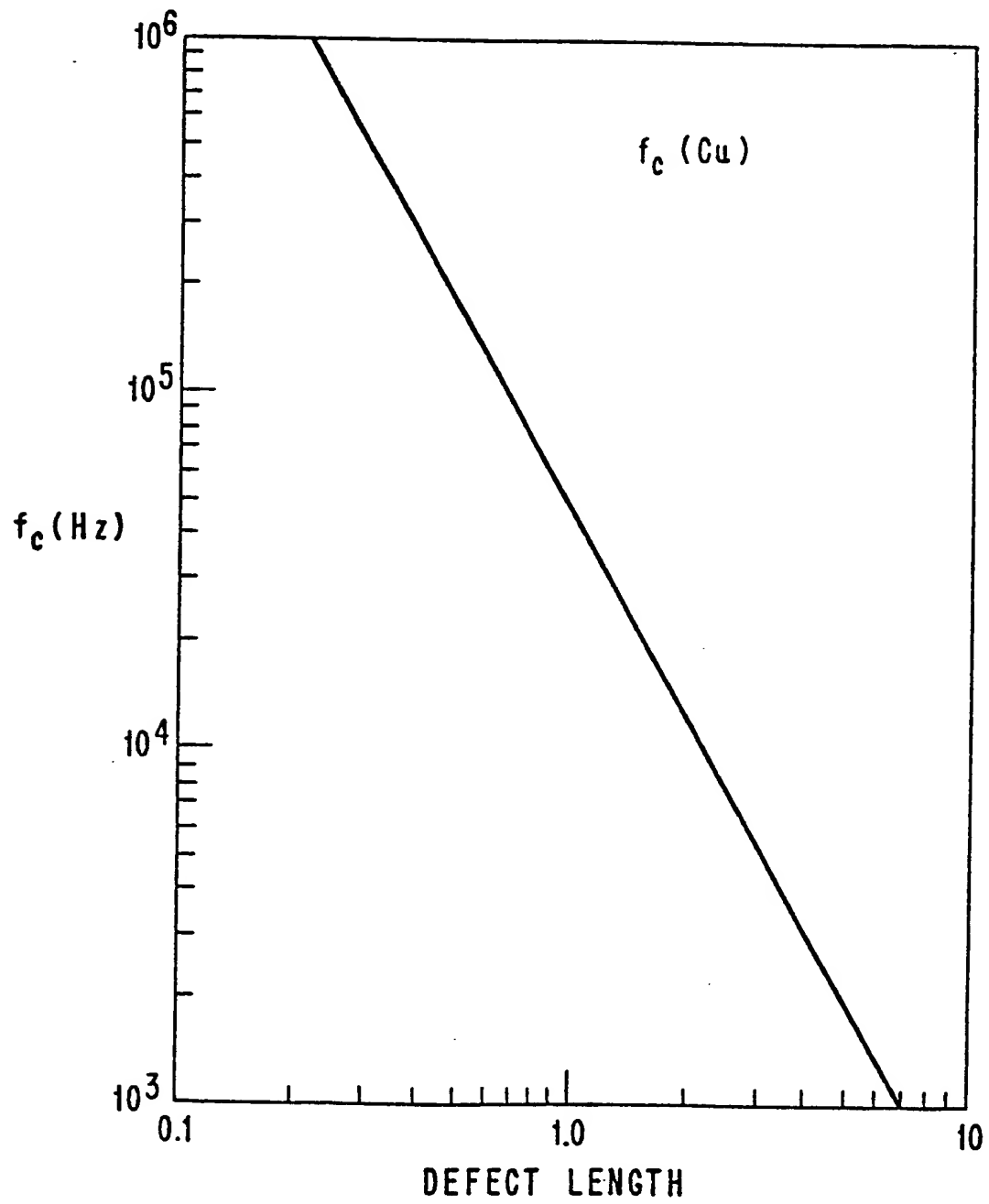
FIG. 10

FIG. 11

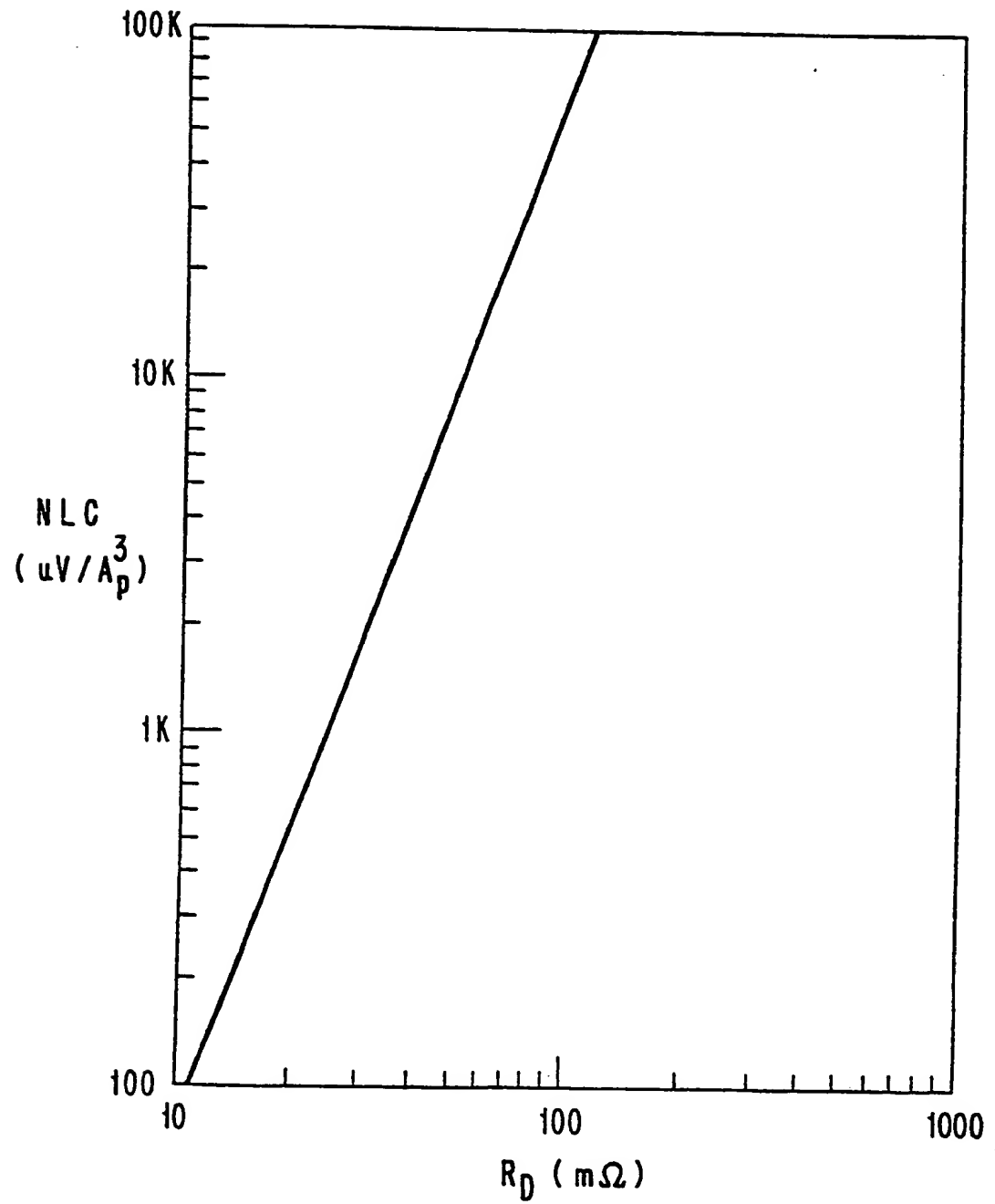
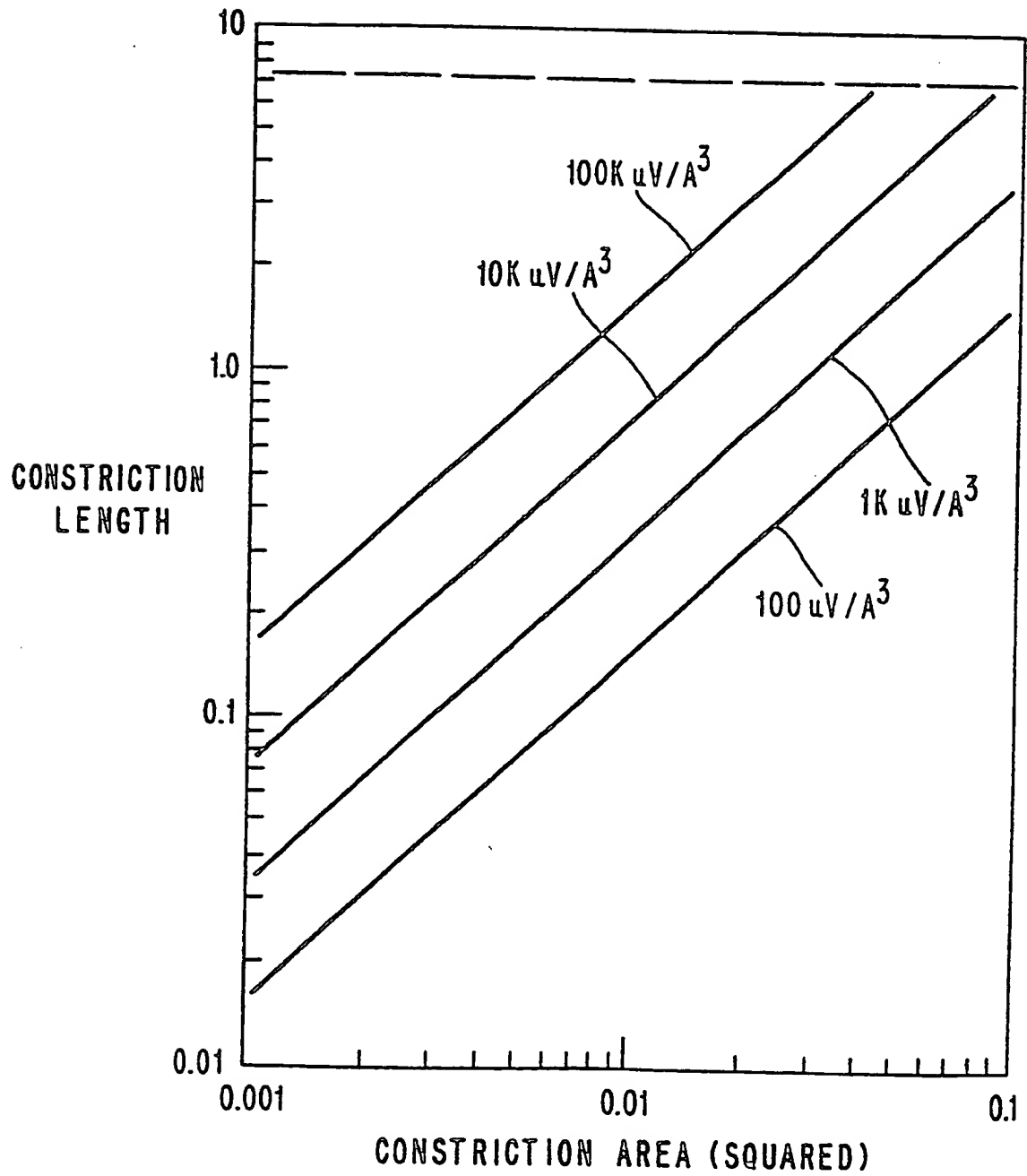


FIG. 12





European Patent
Office

EUROPEAN SEARCH REPORT

0094486

Application number

EP 83 10 2551

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 7)
Y	US-A-3 192 474 (L.B. CHERRY) * Column 1, lines 33-38; column 2, lines 26-36; column 4, line 6 - column 5, line 13; figures 2, 3 *	1,3	G 01 R 27/02 G 01 N 27/20
A	---	5,7	
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The present search report has been drawn up for all claims			
Place of search BERLIN		Date of completion of the search 29-07-1983	Examiner LEMMERICH J
<p>CATEGORY OF CITED DOCUMENTS</p> <p>X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document</p> <p>T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document</p>			